

Tuesday, 4/24/2007 3:14:44 PM
 er: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HI-STEP LEG ASSEMBLY
Job Number : 32032	
Estimate Number : 10385	
P.O. Number : <i>N/A</i>	Part Number : D3065041
This Issue : 4/24/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3065 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 31794	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 5/20/2007 Qty: 60 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.04.25	
Comment : Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	32032A	STEP SPACER
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Comment: Sub-Component STEP SPACER

D3065-1 B *B 31794 (x35)**B 32032 A (x25)**✓ mil*

2.0	32032B	STEP SPACER
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Comment: Sub-Component STEP SPACER

D3065-3 B *B 31794 B (x15)**B 32032 B (x45)**✓ mil*

3.0	32032C	STEP LEG
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Comment: Sub-Component STEP LEG

D3065-5 B *B 28738c (x8)**B 29978c (x112)****

4.0	32032D	STEP SPACER
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Comment: Sub-Component STEP SPACER

D3065-7 B *B 22366 (x9)**B 28738 D (x2)**B 32032(D) (49)**✓ mil*

5.0	MS20470AD44	Rivet, Universal Head
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Comment: Qty.: 30.0000 Each(s)/Unit Total: 1800.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number

30 MS20470AD4-4

Description:

Rivet

Batch

M105125
*M104885 (1800)**✓ mil*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PS Date: 07/08/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/24/2007 3:14:44 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 32032

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



mf 07-08-09
ml
a.m.

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

07.08.

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/09 (60)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W11

a.m. 07.08.09

(X60)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Dealt 10

Job Completion



C207/08/10

H-IFORMS Quality

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

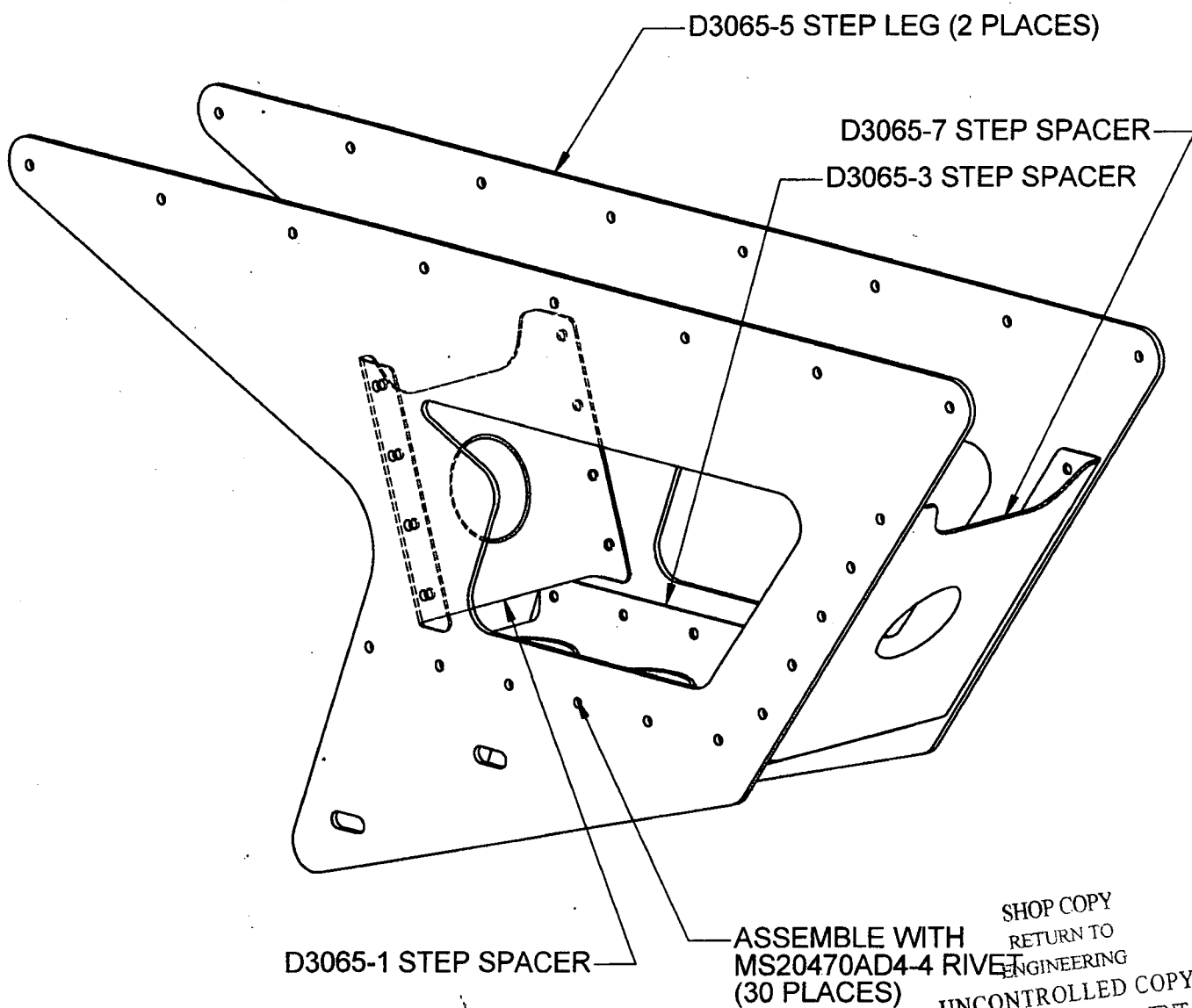
NOTE: Date & initial all entries



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

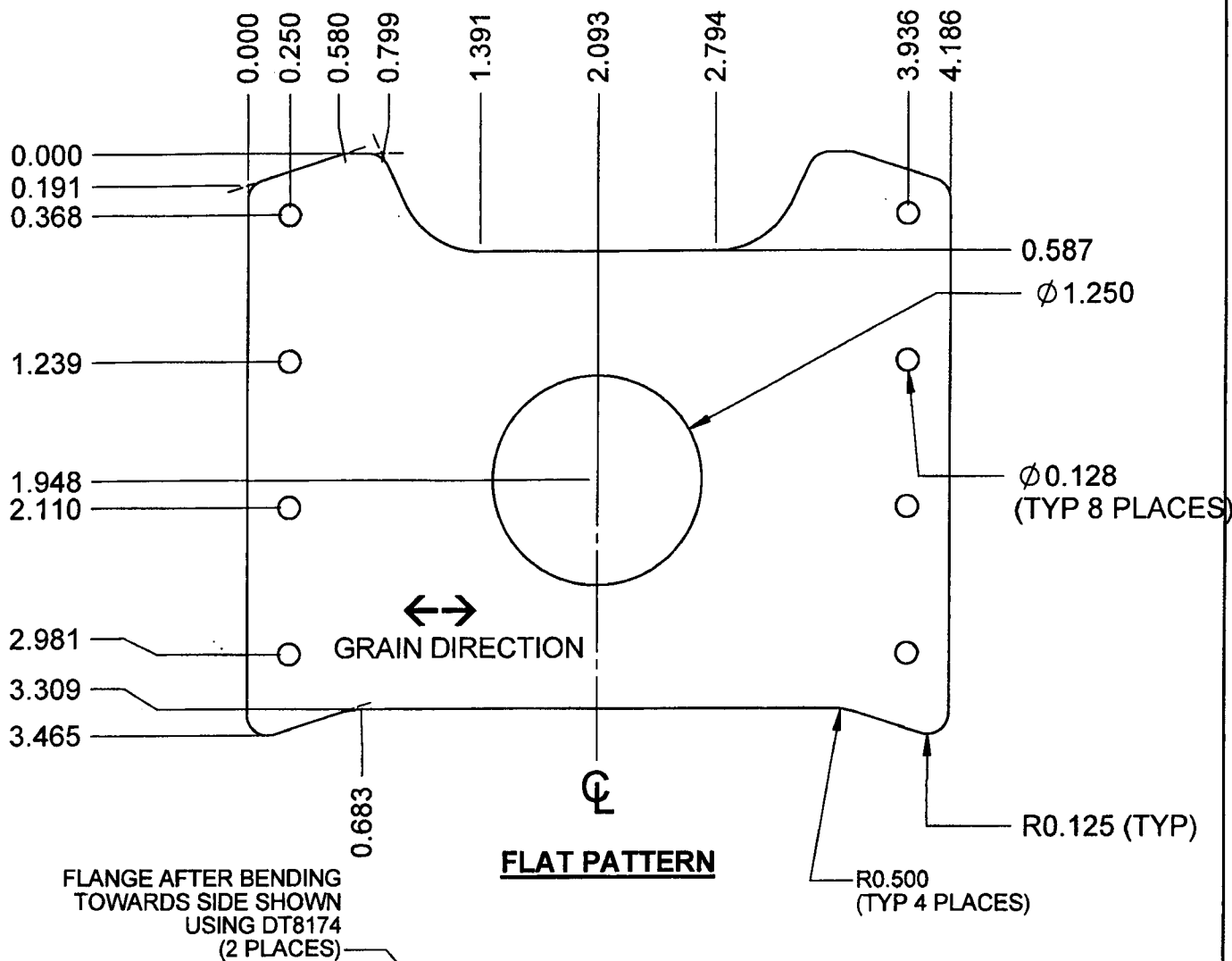
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DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



RELEASED

de de-ro

D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T38.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

BEND DETAIL

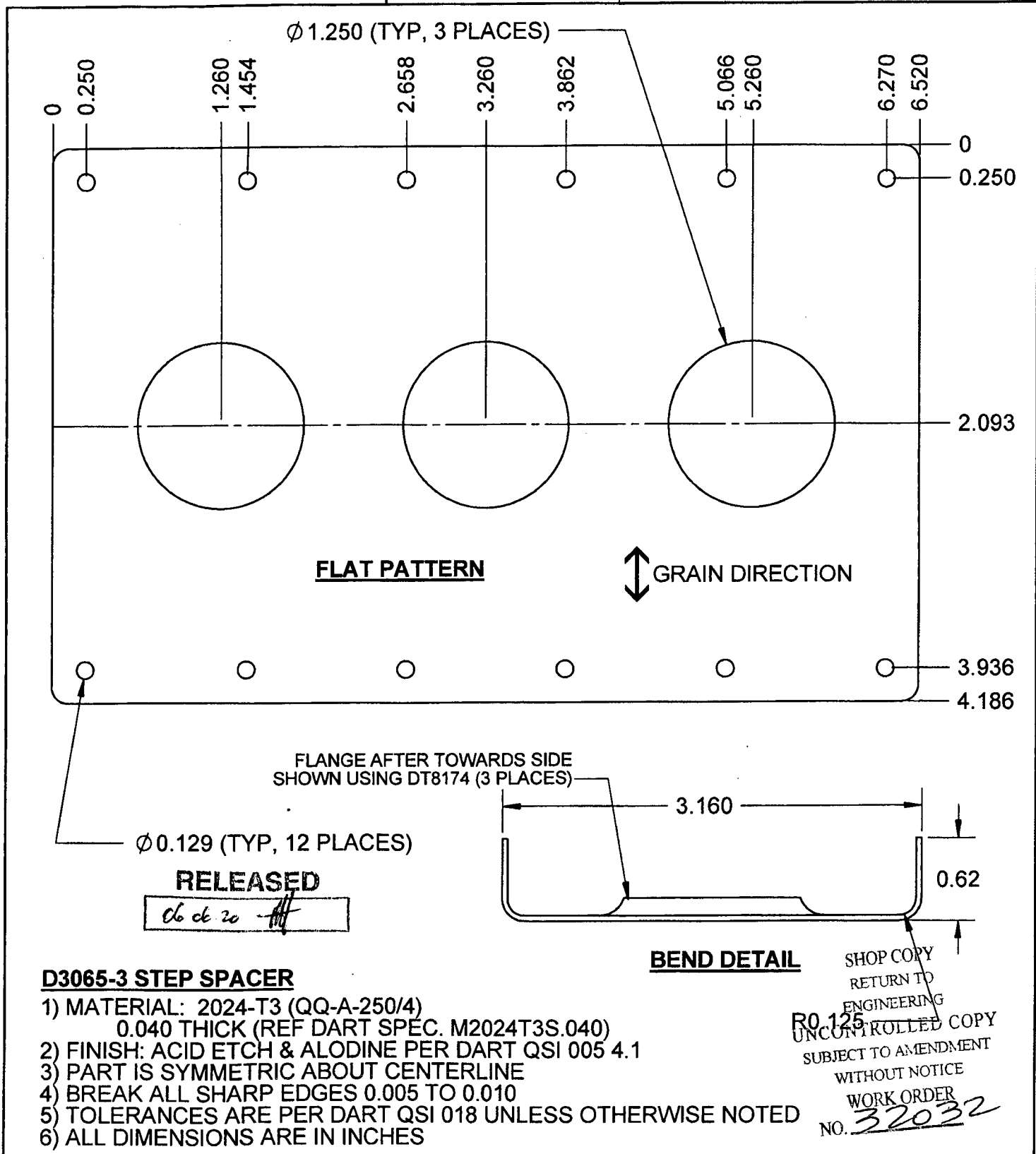
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



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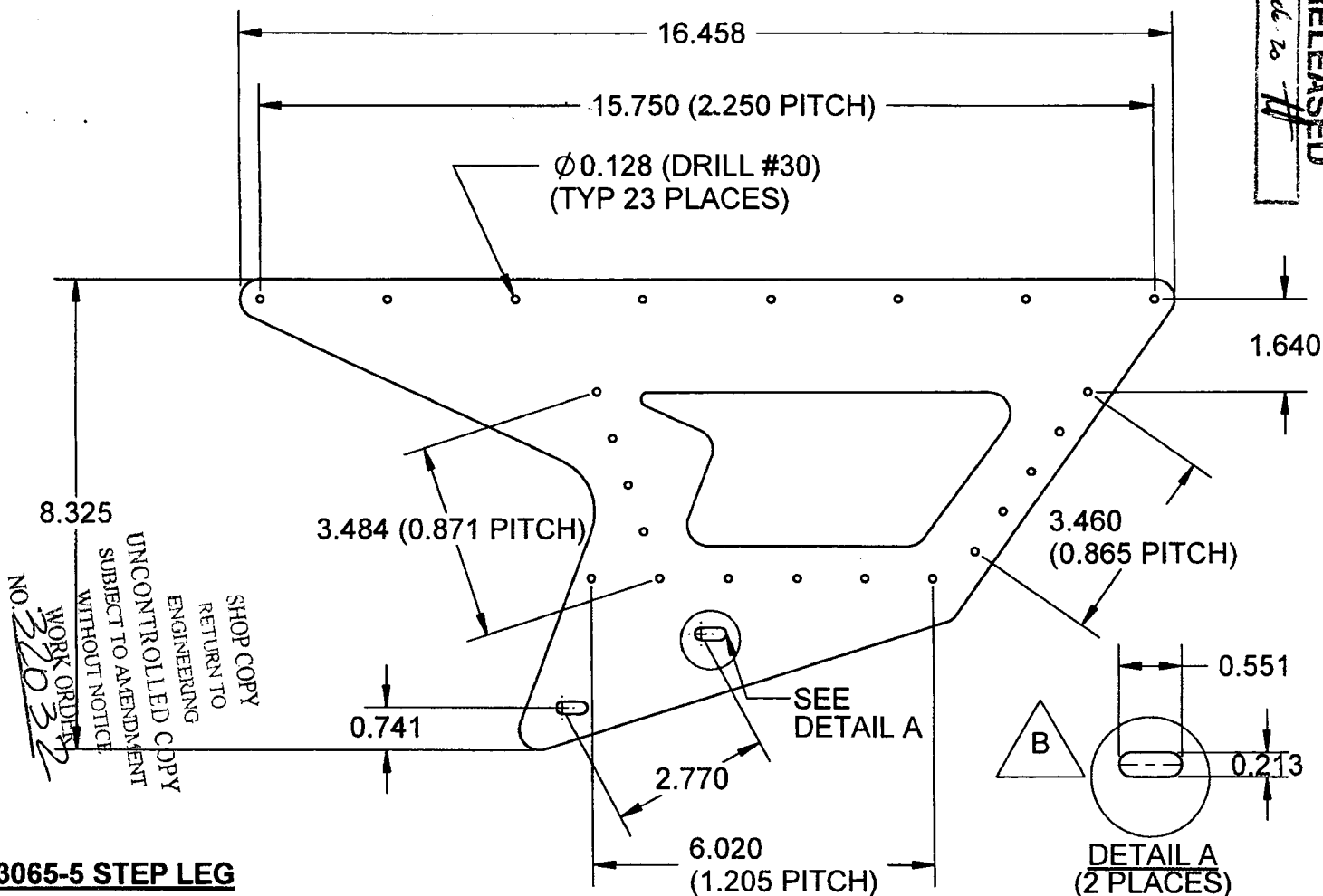
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DART

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CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	REV. B
DATE	06.05.23	DRAWING NO.	D3065	SHEET 4 OF 5
		TITLE	STEP LEG ASSEMBLY	SCALE 1:3

RELEASED

06.05.23



D3065-5 STEP LEG

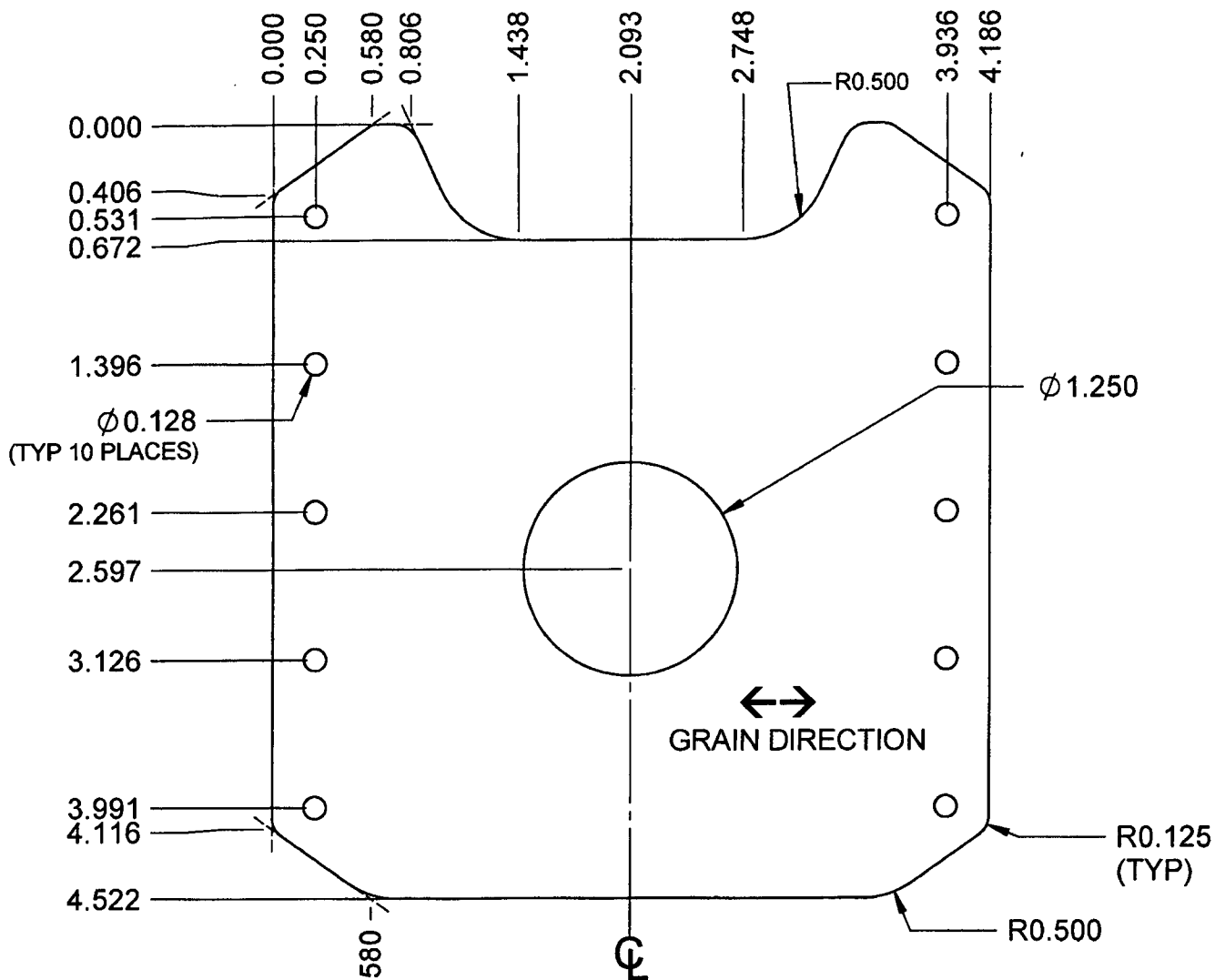
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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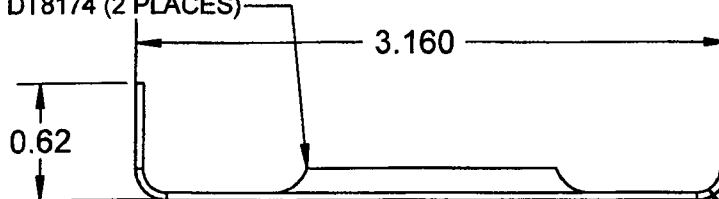


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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



RELEASED

de de ro



BEND DETAIL

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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